

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018863**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 8E/9E Weld ID: E1, Face A (FCAW-G)
- 2). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)
- 3). OBG Field Splice 7W/8W Weld ID: E1 & E2, Face B – (FCAW-G)

- 1). OBG Field Splice 8E/9E Weld ID: E1, Face A (SMAW)

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding of fill and cover passes at the 1st 1000mm of OBG Field Splice 8E/9E Weld E1. See photo below. The welding was performed per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position. The QAI observed QC Inspector Fred Von Hoff were present periodically to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1040A. The welding of fill and cover passes was in process. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)

Interior: OBG 4E PP25 E3 weld 2

The QAI periodically observed AB/F approved welder Salvador Sandoval (ID 2202) performing air carbon arc back gouging & back grinding of (2) two R-2 UT repairs at OBG 4E PP25 E3 weld 2. See photo below. The QAI did not observe repair welding at this location on this date. The QAI observed that the work at this location

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appeared to be in general compliance with contract documents.

3). OBG Field Splice 7W/8W Weld ID: E1 & E2, Face B – (FCAW-G)

The QAI periodically observed AB/F approved welder Rory Hogan (ID 3186) performing cover pass welding per the Flux Cored Arc Welding (FCAW-G) process in the 4G (overhead) position. The QAI periodically observed QC inspector Steve McConnell was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1. 5-3110-4. The welding of cover passes was completed at this location and the work appeared to be in general compliance with contract documents.



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385 5910, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer